

5187667



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2423

Job Sheet 194727



Part No: D2423

Job Qty: 288 ft

Part Name: Lug Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/8/19

Job Tracking No:

Due Date: 6/7/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B1 IPP G 04.09.02 Part Number D2423-108 changed to D2423 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Purchasing - Ft	288 ft	6/7/19	6/7/19	0.00	0.00	Purchasing - 1	ATUM
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	288 pcs	6/7/19	6/7/19	0.00	0.00	Packaging 2 - 1 - B4B	ATUM
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

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				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	288 pcs	6/7/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
130	Packaging 3-1 - Stock - B4B	288 pcs	6/7/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA FT	288 ft	6/7/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

AT VM

JM AT JUN 06 2019

DAS JUN 06 2019

Part Op **100** - (Purchasing) Issue P/O: _____ Manufacture as per Dwg Possible Supplier: SIGNATURE
 Descriptions: ALUMINUM
110 - (Receive & Inspect for Damage & Mat'l Certs)
120 - (QC6- All purchased or subcontracted products)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423P	Lug Extrusion	288 ft (1 ea)	100-Purchasing - Ft	S187543

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D2423P	288	0	0

Part Specifications

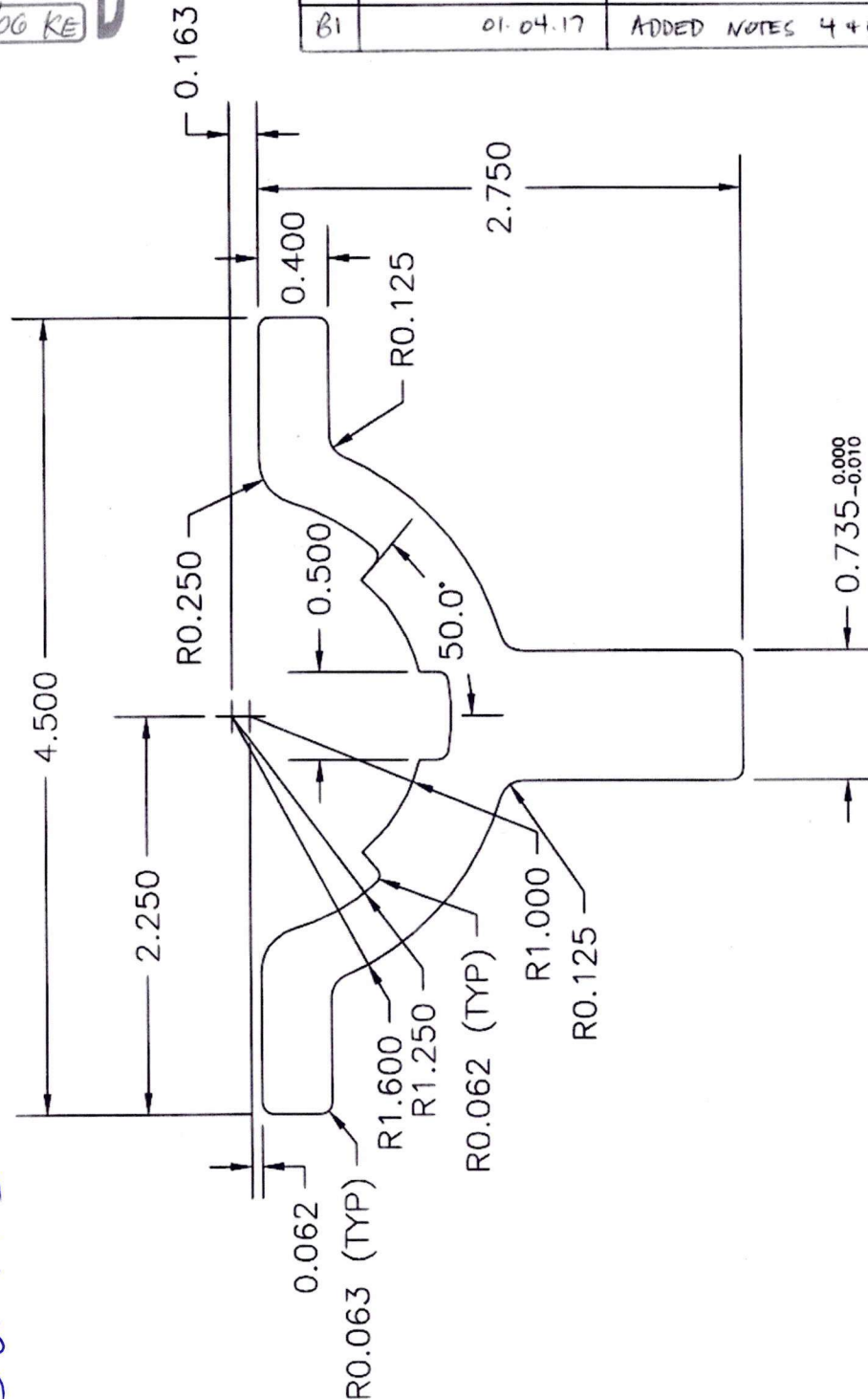
Specifications could not be found.

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DESIGN <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		DRAWING NO. D2423 REV. B SHEET 1 OF 1	
DATE 98.08.04		TITLE LUG EXTRUSION		SCALE 1:1	
A	95.05.09	NEW ISSUE			
B	98.08.04	6061-T6 WAS 6005A.T5			
B1	01.04.17	ADDED NOTES 4+5 <i># CP</i>			

RELEASED
98/08/06 KE



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBON INDEX DIE # MS-10866
5. PART NUMBER IS D2423-XX WHERE XX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108 INCHES)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043403



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043403

PO Date: 5/8/19

Due Date: 6/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

EMAILED
MAY 09 2019

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194727	D2423P		Lug Extrusion : AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG) die # DAA-5-2 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Firmed	-	6/6/19	288 ft	0 ft	288 ft	\$10.3178/ft	\$2,971.53
											Grand Total: \$2,971.53	

216 ft
vm

JUN 04 2019



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043403



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL

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1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU

06-03-19

PACKING LIST NUMBER / N° DE BODEREAU

043099

SALES ORDER NUMBER / N° DE COM

136344

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION

TRAILER NUMBER /
REMORQUE NombreSALESMAN /
VENDEUR

CREDIT REP / REP DU CRÉDIT

SALES REP / REP. DES
VENTES

PIC

T35

042

R. BLAIS

CUSTOMER ID / ID DU
CLIENT

ORDER DATE / DE LA COM

CUSTOMER-PO-NUMBER / CLIENT PO Nombre

POHB043403



JOB / FICHIER

FIELD SALES REP / REP
REGIONAL DES VENTESCUST SERVICE REP / REP.
SERVICE CLIENTELE

46024

05/10/19

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

043099

CARRIER / TRANSPORTEUR
RS BYFORD & SONS

G.ATTENBOROU

D1K

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,140	LB		DAA-5-2	6061 T6		1	811	796	LB	
	517	KG		D2423P	96.0000 IN			368	361	KG	
Y	37	PC			Cut (+): 0.1180 Cut (-): 0.0000	Min: -10 % Max: 10 %			27	PC	
						920312 / 491992	1	811	796		27 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

Page 1 of 1

1	811	796	LB
	368	361	KG
		27	PC
TOTALS			

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CUSTOMER

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
05/30/2019	5532949	136344	1
Cust PO	B/L No	Lot	Date
POHB043403	043099	920312	06/03/19

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	811 LBS		
Net Qty	796 LBS 27 PCS 1 PKGS		
Specification		Die Desc	
(AMS QQA 200/8 + ASTM B221			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
326.2 / 47.3	305.6 / 44.3	15.0	N/A	95

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.62	0.29	0.22	0.06	0.87	0.08	0.10	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

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Rev A

Carrier: RS BYFORD & SONS

Shippers No: 043099

TRL T35

on 06/03/19

From: SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8



ISSUED AT SHIPPER'S REQUEST

EMIS À LA DEMANDE DE L'EXPÉDITEUR

Received, subject to the classifications and tariffs in effect on the date of issue of this Original Bill of Lading, or, received, subject to the Rules for the Carriage of Express and Non-Carload Freight Traffic and tariffs in effect on the date of issue of this Original Shipping Contract (Bill of Lading), goods described below, in apparent good order, except as noted (contents and conditions of contents of packages unknown), marked, consigned and destined as indicated below, which said Company agrees to carry to its usual place of delivery at said destination, if on its road, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any of said goods over all or any portion of said route to destination, and as to each party at any time interested in all or any of said goods, that every service to be performed hereunder shall be subject to all the terms and conditions (which are hereby incorporated by reference and have the same force and effect as if the same were severally, fully and specifically set forth herein).

1. Railway Traffic Liability Regulations (SOR/91-488 August 14, 1991) passage of the National Transportation Act, 1987.
2. of the bill of lading of the water carrier as provided in its tariffs of rules and Regulations when said goods are carried by a water carrier; or
3. of the bill of lading set forth in or prescribed by the relevant tariffs, classification, statutes and regulations pertaining to motor carrier's services when said goods are carried throughout by a motor carrier; or
4. of the bill of lading in Schedule 2 by O.C. 47-88 of January 13, 1988 when said goods originating in Quebec are to be carried by a motor carrier.
5. or approved by the Board of Transport Commissioners for Canada by General Order No. T-43, set forth in the Rules for the Carriage of Express and Non-Carload Freight Traffic and also available at all express and railway agency stations and express and freight offices upon request, when said goods are carried by a rail carrier, and which are agreed to by the shipper and accepted for himself and his assigns.

Reçu, sous réserve des classifications et tarifs en vigueur à la date de livraison de ce connaissance original, ou sous réserve des règlements régissant le transport des messageries et marchandises de détail et des tarifs en vigueur à la date de livraison de ce contrat de transport (connaissance), les marchandises désignées ci-dessous, apparemment en bon état, sauf les remarques contenues aux présentes (le contenu et l'état du contenu des colis étant inconnus), marquées et consignées tel que ci-après indique, et que la Compagnie s'engage à transporter à destination à son lieu habituel de livraison, pourvu que telle destination soit sur son parcours, sinon à les livrer à un autre voiturier faisant route vers cette destination. Il est de plus convenu que tout voiturier transportant tout ou partie desdites marchandises sur tout ou partie du parcours, que toute personne intéressée en aucun temps à tout ou partie desdites marchandises et que tous services prévus aux présentes seront assujettis à toutes les conditions (lesquelles, par renvoi, sont intégrées aux présentes et ont la même force et le même effet que si elles étaient ici énoncées séparément, et intégralement et expressément).

1. Le Règlement sur la responsabilité à l'égard du transport ferroviaire de marchandises (DORS/91 488, 14 août 1991) adoptée en vertu de la loi de 1987 sur les transports nationaux.
2. du connaissance du transporteur maritime, conformément aux dispositions et règlements énoncés dans les tarifs s'appliquant au transport par eau; ou
3. du connaissance prescrit par les tarifs, classifications, statuts et règlements se rapportant aux services de camionnage si lesdites marchandises sont transportées par camion; ou
4. du connaissance selon l'annexe 2 du Décret 47-88 du 13 janvier 1988, si les marchandises sont expédiées de la province de Québec par camion.
5. approuvées par l'ordonnance générale No. T-43 de la Commission Canadienne des Transports pour le Canada régissant le transport des messageries et marchandises de détail et dont le texte peut être obtenu sur demande à toutes les gares de voyageurs et de messageries, ainsi qu'à tous les dépôts de marchandises si lesdites marchandises sont transportées par un voiturier du rail, conditions auxquelles l'expéditeur consent et qu'il accepte pour lui-même et ses ayants droit.

Consigned To: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

S/O: 136344
Freight: Prepaid

No	Description Of Articles	LTL	Haz	Net	Tare	Gross
Pkgs		Cls	Mat			
1	Aluminum Lineal Shapes; Item 13515-A	60		796 lbs 361 kgs	15 lbs 7 kgs	811 lbs 368 kgs

1	TOTAL	796 lbs 361 kgs	15 lbs 7 kgs	811 lbs 368 kgs
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Shipper, Per R1POINT
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

CANADA

CARRIER / AGENT <i>RS BYFORD</i>				CONSIGNEE / CONSIGNATAIRE			
DATE	D/J	M/M	Y/A	DATE	D/J	M/M	Y/A
	03	06	19				
PER / PAR				PER / PAR			

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2423
DATE: June 4 2019

PO / BATCH NO.: POHB043403/
5187543

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 216 FT
QUANTITY INSPECTED: 216 FT
QUANTITY REJECTED: 0

THICKNESS ORDERED: .4"
THICKNESS RECEIVED: .4"
SHEET SIZE ORDERED: -
SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	Y ☒ N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	Y ☒ N	
CORRECT MATERIAL PER M-DRAWING	Y ☒ N	Ams QQA 200/8
CORRECT THICKNESS	Y ☒ N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	Y ☒ N	POHB043403
CORRECT MATERIAL IDENTIFICATION	Y ☒ N	
CORRECT M# ON THE MATERIAL	Y ☒ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>[Signature]</u>	<u>61</u>	SIGNED OFF BY: _____
DATE: <u>JUN 04 2019</u>		DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in